

Date: Thursday, 5/4/2006 10:45:18 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUP
Job Number : 27007	
Estimate Number : 12404	
P.O. Number : N/A	Part Number : D35031
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3503 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SJA COMMENT Below</u>	Due Date : 5/5/2006 Qty: 64 Um: Each
Checked & Approved By : <u>06.05.04</u>	
Comment : Est Rev A New Issue 06-05-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R100	304 ROUND BAR
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Comment: Qty.: 0.0683 f(s)/Unit Total : 4.3680 f(s)
304 ROUND BAR
(M304R1000)
Batch: M100325

M8 06/05/04

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA635 & DWG D3503,
FOLIO REV: A
DWG REV: A

2-DEBURR AS REQUIRED

M8 06/05/04

64

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 06/05/04

64

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M8 06/05/05

64

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: WS

U 26.05.05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 10:45:18 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 27007

Part Number: D35031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: 06/05/05 (61)

Job Completion



Handwritten: U 0608-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

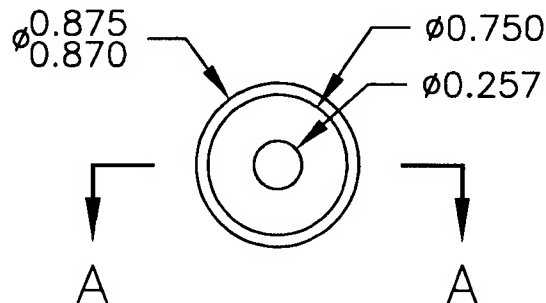
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

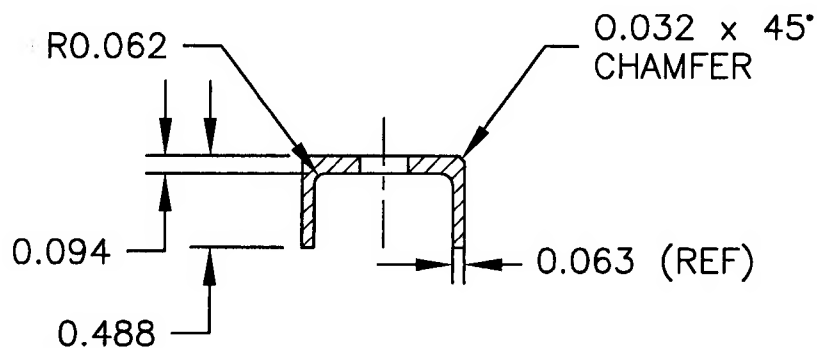
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3503	REV. A SHEET 1 OF 1
DATE 06.04.19		TITLE CUP	SCALE 1:1
A	06.04.19	NEW ISSUE	

RELEASED
06.04.25



D3503-1



SECTION A-A

D3503-1 CUP

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART MATERIAL SPEC M304RX.XXX)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 27007

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27007

UNCLASSIFIED

CUP

Part Number: D3503-1

D3503-1

Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Prototype

	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.875	$\pm .005$ $\pm .000$.875	✓		vern	
.750	$\pm .010$.749	✓			
.257	$\pm .005$ $\pm .000$.258	✓			
.488	$\pm .010$.491	✓			
.094	$\pm .010$.095	✓			
R.062	$\pm .010$.062	✓			
.063	ref.	.063	✓			
.032x450		.032	✓			

Folio approved
 Feb 05-06

folio approved
206-05-08

NS

Audited by: J.L

T.L

Prototype Approval:

06/05/04

Date: 06/05/04

06/05/04

Date:

Revised by _____ Approved _____

KJ:RF

Approved